




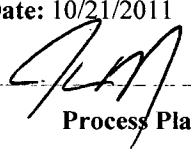







# Work Order ID 73851

Friday, September 16, 2011 12:49:15 PM

Page 1

Item ID:	D2662-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle, RH In 206					
Start Date:	9/16/2011	Start Qty:	10.00		Cust Item ID:	
Required Date:	10/21/2011	Req'd Qty:	10.00		Customer:	
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop
						
						

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2662	Rev D								

100		HAAS CNC VERTICAL MACHINING #1	0.00	B.A 11/09/29	10	0
HAAS 1		Memo	0.00	29 11.9.30		
HAAS CNC vertical machine #1		Program part number and batch number. <input type="checkbox"/> Inspect part number and batch number are programmed correctly. <input type="checkbox"/> Fixturing Inspection last completed <u>B.A</u> by <u>11/09/29</u> <input type="checkbox"/> Machine Step No 1 of Folio and inspect per attached Dimension Sheet <input type="checkbox"/> Machine Step No 2 of Folio				
110		CONVENTIONAL MILLING MACHINE	0.00	B.A 11/09/29	10	1
Mill Conv		Memo	0.00	29 11.9.30		
Conventional Milling Machine		Machine Keyway and inspect per attached dimension sheet				
120		QC2- Inspect parts off machine FAI/FAIB	0.00	B.A 11/09/29	10	1
QC		Memo	0.00	29 11.9.30		
Quality Control						

Dart Aerospace Ltd

W/O: 73851		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2662-2 PAR #: 21A Fault Category: Machining / Program NCR: Yes No DQA: 11.10.14  
11.8.14 Resolution: Scrap Repair Re-work Program Disposition: Scrap QA: N/C Closed: CK Date: 11/10/14

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.9.14	1015	CHAMFER TOOL CUT TOO DEEP ON LARGE BORE (1.575") SURFACE. R. NEW PROGRAM MALFUNCTION R. NEW Program / Process.	CP 11.09.14 PS10M	SCRAP + REPLACE modify + SAVE Qty 1	11.9.14 PS10M	S 11/09/14	CP 11.09.14 PS10M	S 11/09/14

NOTE: Date & initial all entries



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73851

Friday, September 16, 2011 12:49:15 PM

Page 3

Item ID: D2662-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle, RH In 206

Start Date: 9/16/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 BR 11-10-6.

170

Identify as per dwg & Stock Location ST 435

0.00



Packaging

Memo

0.00

Packaging

(10X) SP11-10-5

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/11

MF

11-10-06

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, September 16, 2011 12:49:13 PM

Page 1

Work Order ID: 73851

Parent Item: D2662-2

Parent Item Name: Saddle, RH In 206


Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C000.11.01 ☐ Removed P/O for Powder Coat - in house process ☐ EC  
IPP Rev:D As per Rev D 07-03-19 JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 		Manufactured	No			100	Each	49.0000	1	10			
Saddle Billet												11. 9. 27	

Location

Loc Qty

Loc Code

MAT040

49

64777

20

66965

1

69677

2

70976

10

72225

16

73768

11

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>73851</b>
<b>Description:</b> 206 Saddle, Inboard, Right side		<b>Part Number:</b>	<b>D2662-2</b>
<b>Inspection Dwg:</b> D2662 Rev. D		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5	Date	
A	0.100	0.140	PR.02	0.115	0.114	0.114	0.114	0.114		
B	0.100	0.140		0.132	0.135	0.136	0.139	0.140		
C	1.125	1.145		1.137	1.139	1.140	1.140	1.140		
D	0.615	0.685		0.688	0.685	0.685	0.685	0.685		
E	0.240	0.260		0.250	0.250	0.249	0.244	0.246		
F	1.313	1.343		1.325	1.323	1.323	1.321	1.322		
G	0.210	0.230		0.225	0.222	0.222	0.218	0.222		
H	0.100	0.180		0.132	0.135	0.135	0.135	0.135		
I	2.470	2.510		2.493	2.493	2.493	2.493	2.493		
J	1.565	1.585		1.575	1.576	1.580	1.580	1.579		
K	0.235	0.240		0.238	0.238	0.238	0.238	0.238		
L	0.100	0.120		0.110	0.110	0.110	0.110	0.115		
M	0.990	1.010		0.990	0.990	0.990	0.990	0.990		
N	0.510	0.515		0.514	0.514	0.514	0.514	0.514		
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500		
R	0.313	0.318		0.315	0.315	0.315	0.315	0.315		
S	0.315	0.322		0.317	0.317	0.317	0.317	0.317		
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362		
V	0.787	0.807		0.800	0.797	0.797	0.797	0.797		
W	0.540	0.560		0.550	0.550	0.550	0.550	0.550		
X	1.674	1.684		1.680	1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.257	0.258	0.258	0.258	0.258		
Z	0.912	0.932		0.918	0.922	0.922	0.922	0.922		
AA	0.490	0.510	4	0.497	0.498	0.500	0.500	0.500		
AB	0.178	0.198	RC	0.188	0.188	0.188	0.188	0.188		
AC										
AD										
AE										
AF										
Accept/Reject										

Measured by: <b>B.A</b>	Audited by: <b>Y</b>
Date: <b>11/09/29</b>	Date: <b>11-10-03</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 73851
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b> D2662-2
<b>Inspection Dwg:</b> D2662 Rev. D	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					Date
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20	
A	0.100	0.140	29.02	0.114	0.114	0.114	0.114	0.114	
B	0.100	0.140		0.138	0.138	0.138	0.138	0.138	
C	1.125	1.145		1.139	1.140	1.140	1.140	1.140	
D	0.615	0.685		0.685	0.685	0.685	0.685	0.685	
E	0.240	0.260		0.245	0.246	0.246	0.246	0.246	
F	1.313	1.343		1.322	1.322	1.322	1.322	1.322	
G	0.210	0.230		0.219	0.220	0.223	0.223	0.223	
H	0.100	0.180		0.135	0.135	0.135	0.135	0.135	
I	2.470	2.510		2.493	2.493	2.493	2.493	2.493	
J	1.565	1.585		1.580	1.580	1.580	1.580	1.580	
K	0.235	0.240		0.238	0.238	0.238	0.238	0.238	
L	0.100	0.120		0.115	0.115	0.115	0.115	0.115	
M	0.990	1.010		0.990	0.990	0.990	0.990	0.990	
N	0.510	0.515		0.514	0.514	0.514	0.514	0.514	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		0.315	0.315	0.315	0.315	0.315	
S	0.315	0.322		0.317	0.317	0.317	0.317	0.317	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		0.797	0.797	0.797	0.797	0.797	
W	0.540	0.560		0.550	0.550	0.550	0.550	0.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		0.258	0.258	0.258	0.258	0.258	
Z	0.912	0.932		0.922	0.922	0.922	0.922	0.922	
AA	0.490	0.510		0.500	0.500	0.500	0.500	0.500	
AB	0.178	0.198	29	0.188	0.188	0.188	0.188	0.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	A.A. 29
Date:	11/09/29 11.2.30

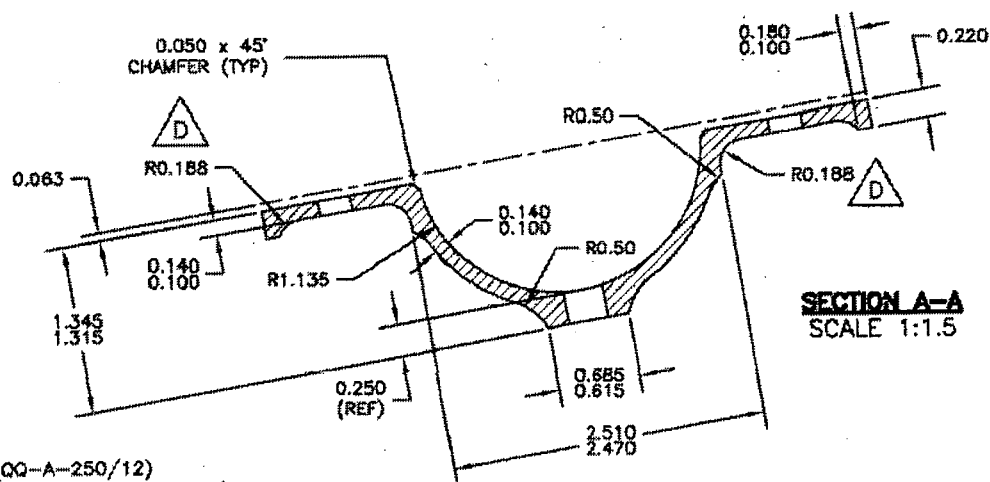
Audited by:	J
Date:	11-10-03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



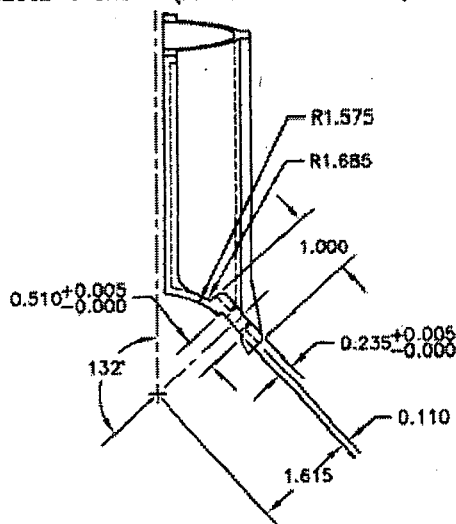
DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2662	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE INSIDE	SCALE 1:3	
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORP' DEO 9122/9102/9095/9137	
D	06.11.08	RO.188 WAS RO.30; Ø0.316 WAS Ø0.313	

RELEASED  
07.02.02 #

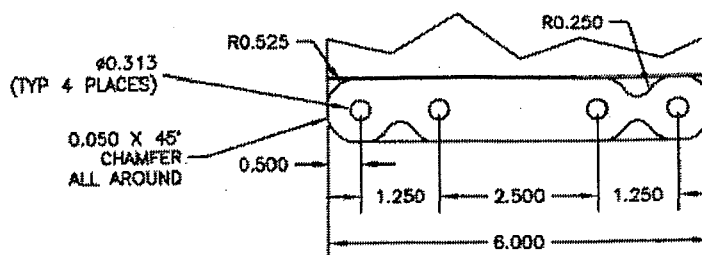
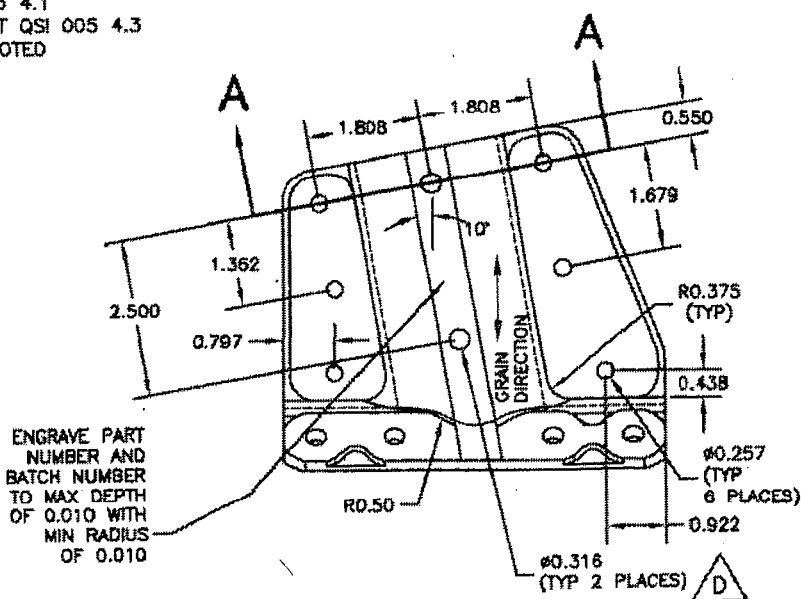


#### NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) D2662-1 SHOWN (D2682-2 IS OPPOSITE)



**D2662-1 SADDLE INSIDE**



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